

Date: Tuesday, 4/18/2006 10:01:47 AM
 User: Kim Johnston

Process Sheet

21

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER INSTALLATION
 Job Number : 26665 *2*
 Estimate Number : 12188
 P.O. Number : *NIA* Part Number : D205706013
 This Issue : 4/18/2006 S.O. No. : *NIA* Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : *NIA* Type : LARGE FAB ASSY Drawing Revision : N/A
 Previous Run : 26402 Material : *NIA*
 Written By : *SEAN COMMENT REW* Due Date : 5/24/2006 Qty: *3* Um: Each
 Checked & Approved By : *06.04.18*
 Comment : Est Rev: 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-706-013CHG001

06-05-05 *3*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D20014	Valve 1/4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2001-4

Valve Assembly

*B22996x1**2x B23276*

4.0	D3262041	Fuel Purge Canister
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3262-041

Canister Assembly

B23284

5.0	D32641	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3264-1

Bracket

B23285

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Part Number: D205706013

Job Number:



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6.0	D329710121	HOSE ASS'Y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose Ass'y

Qty	Part Number	Description	Batch
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1	D3297-1-0121	Hose Assembly	B23287 X
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7.0	D329710130	HOSE ASS'Y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose Ass'y

Qty	Part Number	Description	Batch
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1	D3297-1-0130	Hose Assembly	B23288 X
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8.0	D329730350	HOSE ASS'Y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose Ass'y

Qty	Part Number	Description	Batch
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1	D3297-3-0350	Hose Assembly	B23291 X
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9.0	D3298001	Tube Assembly 25"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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1	D3298-001	Tube Assembly	B23293 X
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10.0	D3298009	Tube Assembly 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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1	D3298-009	Tube Assembly	B23297 X
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11.0	D32991	Fitting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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1	D3299-1	Fitting	B22648 x1 X B23301A x1 X B23301B x1 X
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26665

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D32993

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting

B23302 X

13.0

D33011

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-1

~~Doubler~~

B23304 Placard X

14.0

D33013

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-3

Placard

B23305 X

15.0

D33021

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler

B23306 x2 X

16.0

D33023

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-3

Doubler

B23314 x2 X

17.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-5A

Bolt

M15205 X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 26665

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN8146D

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN814-6D

Plug

M17654 ✓

19.0

AN8156D

Union-M-Flare



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN815-6D

Union

M16463 x2

4x M16895 X

20.0

AN8336D

Elbow, Bulkhead-M-Flare



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~12~~ 9.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 AN833-6D

Elbow

M17654 ✓

2x M19620 ✓

1x M17301 ✓

21.0

AN9246D

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN924-6D

Nut

M17654 X

22.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M100793 X

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD10L

Washer

M18235 X

24.0

AN960JD916

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN960JD916

Washer

MISSOS X

25.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3

Nut (or -3)

M18917 X

26.0

MS21919WDG9

Clamp



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS21919WDG9

Clamp

M17712 X

27.0

MS21919WDG12

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

1

MS21919WDG12

Clamp

M12010 X

28.0

MS21919WDG16

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

2

MS21919WDG16

Clamp

M16322 X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 26665

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

MS2192042

CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M18048 X

30.0

MS287786

Packing



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS28778-6

O-Ring

M17654 X

31.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 MS35489-11

Grommet

M16323 X

AP 06/05/04

(2)

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD205-706-013

Location:

PPP Rev:

B

06/05/05 (2)

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/05 (2)

Job Completion



06/05/05

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